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D4635-141
Job Sheet 202528



Part No: D4635-141

Job Qty: 1 pcs

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4635 REV.G SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver:DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL IPP REV:G 19.05.14 AS PER DWG REV.G DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Small Fab - 1	1 pcs	11/15/19		0.00	1.47	Small Fab - 1			NOV 08 2019
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
							Small Fab - 8			
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10			NOV 08 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
130	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B			NOV 08 2019
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	NOV 11 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (Small Fab) Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 5214187 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 5159491 Expiry Date 02/07/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: m138961
 120 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-1	Fwd Ceiling Panel, LH	1 pcs (1 ea)	110-Small Fab - 1	5134135
D4669-1	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5122038
D4695-041	Channel Assembly, LH	1 pcs (1 ea)	110-Small Fab - 1	5025561
D4732-29	Label <u>5224588</u>	1 pcs (1 ea)	110-Small Fab - 1	5060906
D4732-33	Label <u>5224655</u>	1 pcs (1 ea)	110-Small Fab - 1	5060908
D4732-5	Label <u>5224151</u>	1 pcs (1 ea)	110-Small Fab - 1	5060908
D4732-9	Label <u>5224351</u>	1 pcs (1 ea)	110-Small Fab - 1	5130408
D5022-1	Foam, Side Panel, Fwd	1 pcs (1 ea)	110-Small Fab - 1	5130408
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	110-Small Fab - 1	5130408 1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4635-1	1	3	0
	D4669-1	2	21	0
	D4695-041	1	3	0
	D4732-29	1	15	0
	D4732-33	1	15	0
	D4732-5	1	15	0
	D4732-9	1	25	0
	D5022-1	1	7	0
	MPNY-750S-9-C	7	104	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS	
Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042)
Description Work Order Deviation		Disposition	
Root Cause		FAULT CATEGORY	
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
		Completed By	
		Lead hand / Supervisor	
		QC / QA Coordinator	